

Work Order ID 80902

Monday, March 05, 2012 9:58:13 AM

80902

Page 1

today

Item ID: D3874-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector

Start Date: 3/5/2012 Start Qty: 1.00

4

Cust Item ID:

Required Date: 3/5/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-03-05* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Qty Reject Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3874

A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

Wh
12/03/07

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240° F*Time IN: *7:00 am 12/03/06*Time OUT: *6:00 am 12/03/07*

x2

Wh
12/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

110

0.00

110

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474
Dwg Rev: A
Folio Rev: B

x2.

OK
12/03/07

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

x2

OK
12/03/07

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

X2

OK
12/03/08

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

DL
12/03/08

150

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x2

DL
12/03/08

160

0.00

160

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

5/12/03/08

(42)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: Date:

Run Start ***NR1***

QC: Date:

Stop ***NR2***

Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

12/3/8 2

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/03/08

12-03-8

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 05, 2012 9:58:12 AM

Page 1

Work Order ID: 80902

Parent Item: D3874-2

Parent Item Name: Floor Protector

Start Date: 3/5/2012

Required Date: 3/5/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Material 10/04/21 DL

IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	1,503.3969	4.38	4.38			

Location

therm

113127

Loc Qty

1503.396941

1503.39694

Loc Code

8.76 sq ft

OK
12/03/00

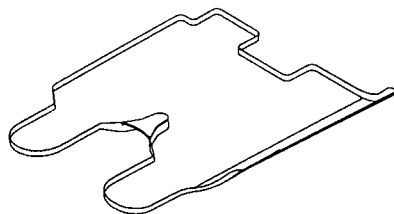
W/O:		WORK ORDER CHANGES					
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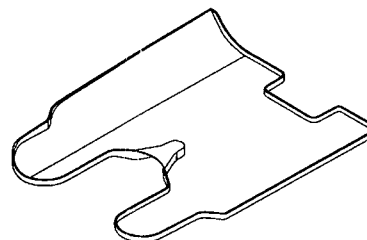
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

RELEASED
09/05/02

80902

A	NEW ISSUE		PH	09.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED	PH	DRAWING NO.	REV. A	
MFG. APPR.	PH	D3874	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	FLOOR PROTECTOR	NTS	
DATE	09.01.29		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

8 7 6 5 4 3 2 1

D

C

B

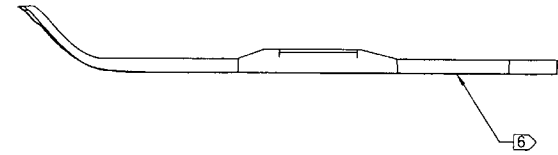
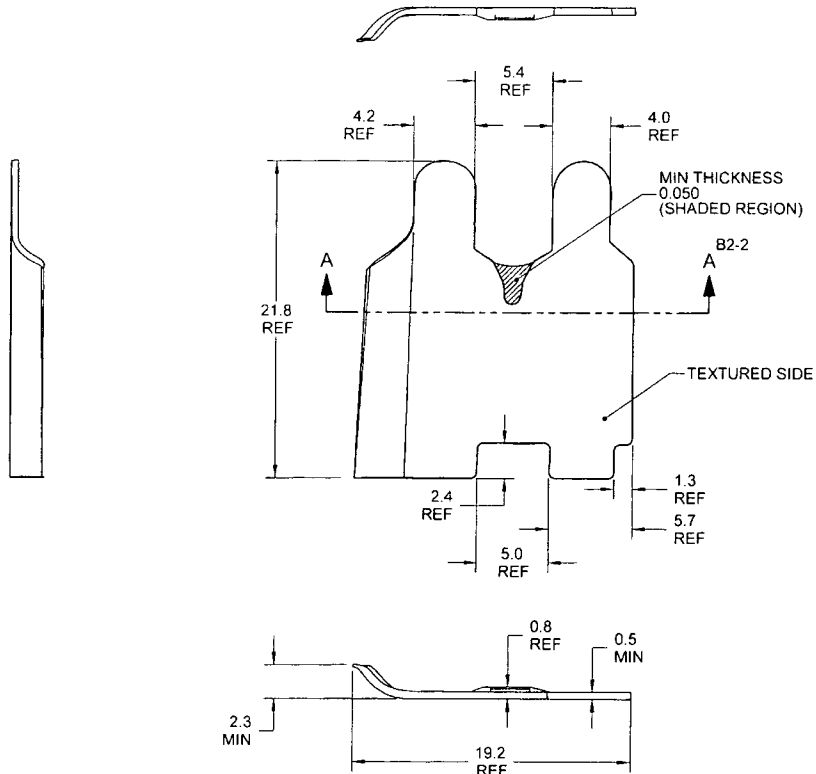
A

D

C

B

A



SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

#80902

RELEASED
9/25/05

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN	PT	DART AEROSPACE LTD	
DRAWN	PT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO.	REV. A
MFG. APPR.	PT	D3874	SHEET 2 OF 3
APPROVED	PT	TITLE	SCALE
DE APPR.	PT	FLOOR PROTECTOR	NTS
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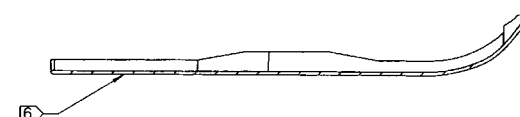
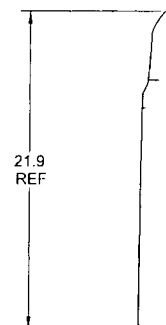
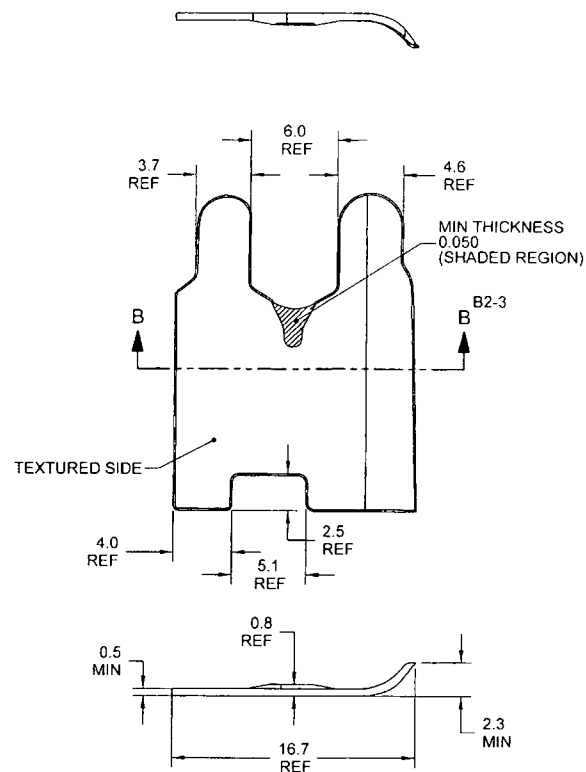
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

80902

RELEASED
9/15/02

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D3874	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD		Work Order:	50902
Description: Floor Protector		Part Number:	D3874-2
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	Wk.	Date:	12/03/07
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.095"	✓		CAL TH-DT	
0.065	Min	0.105"	✓		CAL TH-DT	
0.5	Min	0.545"	✓		VERM DL-02	
21.9	REF	21.9. "	✓		TAPE DL-01	

Measured by:	Ok	Date:	12/03/08
Audited by:	BB	Date:	12/03/08
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	MA

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